

# Work Order ID 66563

Tuesday, February 22, 2011 10:02:59 AM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Item Name: Handle Weldment

Stop



Start Date: 2/23/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-02-22* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2530

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536  
2-Deburr

*=> m L 11/02/24*

*(7X)*

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

*Rpl 11.03.08*

120

Weld per dwg A/R S.S. rod Batch: *115928*

0.00



Small Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

*Rpl 11.03.08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66563

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Item Name: Handle Weldment

Start Date: 2/23/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

7 0 BE 11/03/10

140 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8 ulos/11



150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00



Powdercoat Memo 0.00

Powder Coating

M112588

START TIME: 11:00  
OVEN TEMPERATURE: 320°  
FINISH TIME: 11:30

7 BR 11-3-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66563

Tuesday, February 22, 2011 10:02:59 AM



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Item ID: D2530

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

Start Date: 2/23/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

7 0 11/03/15

170 Identify as per dwg & Stock Location

0.00



Packaging Memo

0.00

Packaging

11/3/16 708

180 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/3/17 22 11/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, February 22, 2011 10:02:56 AM

Page 1

Work Order ID: 66563

Parent Item: D2530

Parent Item Name: Handle Weldment



Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F  
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2534

Manufactured

No

120

Each

14.0000

2

20



Lock Plate

*Handwritten:* P/C 11-03-08 366807 → 20/14

Location

Loc Qty

Loc Code

WA020

14

64929

14

M304TR0.750W.049

Purchased

No

100

f

59.4213

2.9145

30.67895

*Handwritten:* 21.4754



304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT

53.8013

108498

0

110113

0

115010

12.264255

1x 116108 ✓

7.15094

6x 116720 ✓

34.386105

MAT014

0.00003

115990

0.00003

MAT017

5.62

109314

4.33

110113

1.29

*Handwritten calculations:*  
18.40745 - 487 = 3.048

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. B
		D2530	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

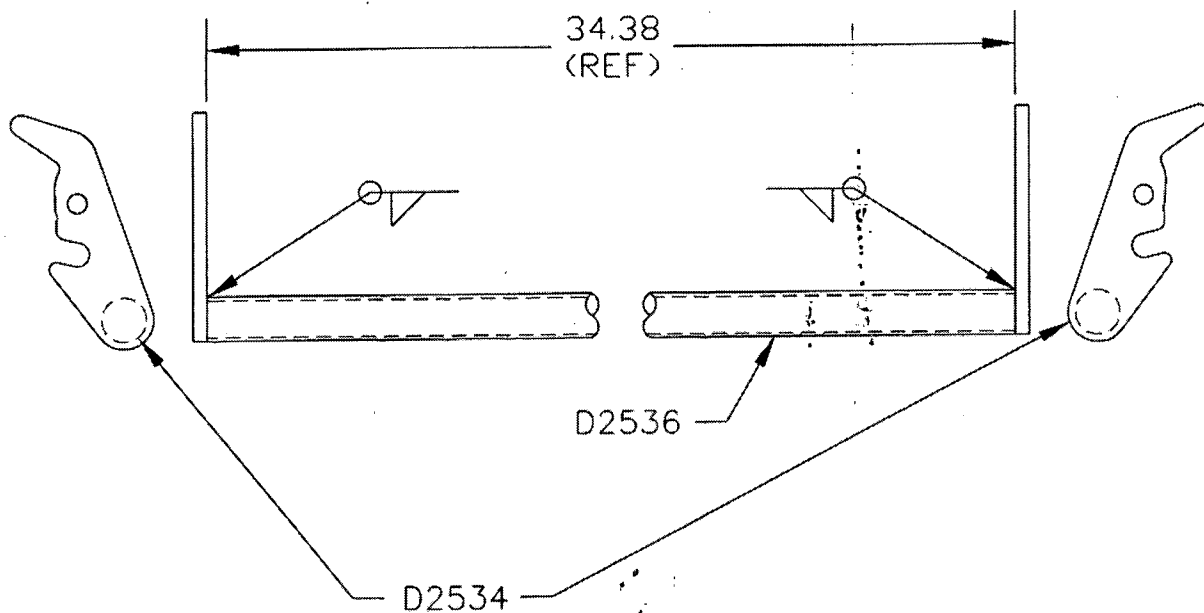
RELEASED

04.12.16 *[Signature]*

## PART LIST -- D2530

*\* 00503*

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4:3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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